

claims

1. A production method of a tablet including at least active substance by means of a die and a pair of punches, comprising steps of;

a - preparing molding material including said active substance;

b - housing said die and said pair of punches in a spraying chamber;

c - generating pulsating vibration air and spraying lubricant mixed in air in said spraying chamber;

d - applying lubricant on the surfaces of said die and said pair of punches housed in said spraying chamber while the lubricant sprayed in said spraying chamber is mixed with said pulsating vibration air; and

e - tabletting said molding material by means of said die and said pair of punches on which surfaces said lubricant is applied.

2. A production method of a tablet including at least active substance by means of a die and a pair of punches, comprising steps of;

a. preparing molding material including said active substance;

b. housing said die and said pair of punches in a spraying chamber;

c. spraying lubricant mixed in pulsating vibration air in said

spraying chamber;

- ↳ applying lubricant on the surfaces of said die and said pair of punches housed in said spraying chamber; and
- ↳ tabletting said molding material by means of said die and said pair of punches on which surfaces said lubricant is applied.

3. The tablet production method as set forth in claim 2, wherein said pulsating vibration air is a positive pulsating vibration air.

4. A production method of a tablet including at least granule containing active substance by means of a die and a pair of punches, comprising steps of:

↳ mixing granule containing active substance and diluting agent uniformly and preparing molding material including said granule containing active substance;

↳ housing said die and said pair of punches in a spraying chamber;

↳ generating pulsating vibration air and spraying lubricant mixed in air in said spraying chamber;

↳ applying lubricant on the surfaces of said die and said pair of punches housed in said spraying chamber while the lubricant sprayed in said spraying chamber is mixed with said pulsating vibration air; and

↳ tabletting said molding material including granule

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containing said active substance by means of said die and said pair of punches on which surfaces said lubricant is applied.

5. A production method of a tablet including at least granule containing active substance by means of a die and a pair of punches, comprising steps of;

mixing granule containing active substance and diluting agent uniformly and preparing molding material including said granule containing active substance;

housing said die and said pair of punches in a spraying chamber;

spraying lubricant mixed in pulsating vibration air in said spraying chamber;

applying lubricant on the surfaces of said die and said pair of punches housed in said spraying chamber; and

tableting said molding material including granule containing said active substance by means of said die and said pair of punches on which surfaces said lubricant is applied.

6. The tablet production method as set forth in claim 5, wherein said pulsating vibration air is a positive pulsating vibration air.

7. The tablet production method as set forth in any one of claims 4 - 6, whereinsaidgranulecontainingactivesubstanceisgranule

including active substance and diluting agent.

8. The tablet production method as set forth in any one of claims 4-6, wherein said granule containing active substance is granule including active substance in base matrix.

9. The tablet production method as set forth in ~~any one of claims~~
^{claim 4} 4-8, wherein said granule containing active substance is granule of which part containing active substance is covered with film.

10. The tablet production method as set forth in claim 1 or 4, wherein following steps are continuously executed;

preparing molding material including said active substance;

housing said die and said pair of punches in said spraying chamber;

generating pulsating vibration air, spraying lubricant mixed in air in said spraying chamber, and applying the lubricant on the surfaces of said die and said pair of punches while the lubricant sprayed in said spraying chamber is mixed with pulsating vibration air; and

tableting said molding material by means of said die and said pair of punches on which surfaces said lubricant is applied.

11. The tablet production method as set forth in claim 2 or

5, wherein following steps are continuously executed;
preparing molding material including said active substance;
housing said die and said pair of punches in said spraying chamber;
spraying lubricant mixed in positive pulsating vibration air in said spraying chamber, and applying the lubricant on the surfaces of said die and said pair of punches; and
tabletting said molding material by means of said die and said pair of punches on which surfaces said lubricant is applied.

12. The tablet production method as set forth in any one of claims ~~4 - 11~~^{y-6}, wherein said punches and said die construct a female mold of a tablet having an engraved mark or a dividing line and an anomalous tablet.

13. The tablet production method as set forth in ~~any one of claims 1 - 12~~^{Claim 12}, wherein tabletting pressure of said step for tabletting said molding material by means of said lubricated die and pair of punches is low.

14. The tablet production method as set forth in ~~any one of claims 1 - 13~~^{Claim 13}, wherein the amount of lubricant sprayed in said spraying chamber is greater than or equal to 0.0001 weight percent and less than or equal to 0.2 weight percent per a tablet.

15. A tablet containing active substance, wherein lubricant is provided only on the surface thereof and amount of lubricant is greater than or equal to 0.0001 weight percent and less than or equal to 0.2 weight percent per a tablet.

16. A tablet including granule containing active substance in diluting agent, wherein lubricant is provided only on the surface thereof.

17. The tablet as set forth in claim 16, wherein said granule containing active substance is granule containing active substance and diluting agent.

18. The tablet as set forth in claim 16, wherein said granule containing active substance is granule including active substance in base matrix.

19. The tablet as set forth in any one of claims 16 - 18, wherein said granule containing active substance is granule of which part containing active substance is covered with film.

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20. The tablet as set forth in any one of claims 16 - 19, wherein amount of lubricant is greater than or equal to 0.0001 weight % and less than or equal to 0.2 weight percent per a tablet.

Claim 19

15-18
21. The tablet as set forth in any one of claims 15-20, wherein a dividing line for dividing the tablet is provided on the surface thereof.

15-18
22. The tablet as set forth in any one of claims 15-21, wherein shape of the tablet is anomalous.

claim 20
23. The tablet as set forth in ~~any one of claims 15-22~~, wherein standard deviation of disintegrating time of the tablet or elution time of the active substance is less than or equal to 15 percent of average disintegrating time or average elution time. 112

claim 23
24. The tablet as set forth in ~~any one of claims 15-23~~, wherein said lubricant is magnesium stearate.

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